

ABSTRACT OF THE DISCLOSURE

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A method for manufacturing a spark plug having a center electrode, an insulator disposed around the center electrode, a metallic shell disposed around the insulator, a ground electrode disposed in opposition to the center electrode so as to form a spark discharge gap therebetween, and a chip of a high melting point metal welded to at least the ground electrode. A zinc-based plating layer is formed on the surface of a metallic shell assembly composed of the metallic shell and the ground electrode, a root-end of which is welded to the metallic shell. Subsequently, the zinc-based plating layer is removed from a free-end portion of the ground electrode. The chip of a high melting point metal is welded to the free-end portion of the ground electrode from which the zinc-based plating layer has been removed.

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